

What is claimed is:

1. In an injection mold arrangement which comprises a mold unit including upper and lower molds jointly defining a mold cavity; and a cold runner device comprising a cold runner block attached to the upside of the upper mold through the intermediary of a thermal insulation material layer and forming a cold runner through which to feed a molding material injected from an injection nozzle of an injection machine, and a nozzle block attached to the underside of the cold runner block to constitute an injection nozzle for charging the molding material through the cold runner into the mold cavity,

a nozzle mechanism of the cold runner device constructed so that the nozzle block comprises a nozzle body having an internal hole communicating with the cold runner, and a nozzle piece having a gate formed of a throttle orifice;

the nozzle piece is held within a lower part of the nozzle body so as to be capable of advancing or receding in the feeding direction of the molding material with its lower tip face protruded downwardly;

and a lower tip face of the nozzle piece may be brought into pressure contact with the perimeter of an injection port at the upper mold to the mold cavity by reason of a feeding pressure of the molding material.

2. The nozzle mechanism of the cold runner device in an injection mold arrangement as claimed in claim 1,

wherein a cylindrical piece is secured to the internal hole of the nozzle body by threading engagement means with its lower extremity protruded downwardly; said nozzle piece is loose fitted in said cylindrical piece and held to be capable of advancing or receding in the feeding direction of the molding material, with a lower tip portion thereof protruded downwardly of the lower extremity of the cylindrical piece.

3. The nozzle mechanism of the cold runner device in an injection mold arrangement as claimed in claim 2,

wherein said cylindrical piece has a slightly smaller diameter at its lower end opening part than at its upper part to form a step portion inboard of the lower end opening part;

and said nozzle piece loose fitted in said cylindrical piece is formed to be smaller in diameter at its lower part than at its upper part so as to enable the loose

fitting of the lower part into the lower end opening part, thus forming a stepped overhang portion between the upper part and the lower part so that the stepped overhang portion may be engaged with the step portion in the inner periphery of the cylindrical piece, thereby regulating the downward displacement of the nozzle piece.

4. The nozzle mechanism of the cold runner device in an injection mold arrangement as claimed in claim 1,

wherein said nozzle piece assumes a tapered form, with its upper nozzle hole part located above the gate is larger in size than its lower nozzle part located below the gate.

5. The nozzle mechanism of the cold runner device in an injection mold arrangement as claimed in claim 1,

wherein said nozzle block is provided with a flow duct for cooling medium, said flow duct being formed by a flow passage helically turning around said internal hole.